



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

D212-664-101
Job Sheet 174838



Tel (613) 632-5200

Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove Coments on Pick List JLM IPP
Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I
14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/29/18	3/29/18	0.00	0.00	Start Up Stores/Pkg-1		GP
110	Packaging	1 pcs	3/29/18	3/29/18	0.00	0.00	Packaging1-3		GP
120	CNC Bend Crosstubes	1 pcs	3/29/18	3/29/18	3.11	2.22	CNC Bend Crosstube		GP 18/04/2
130	QC	1 pcs	3/29/18	3/29/18	0.00	0.00	QC15		GP
140	Crosstubes	1 pcs	3/29/18	3/29/18	0.00	0.67	Crosstubes-1		GP
150	HandFXtube	1 pcs	3/29/18	3/29/18	0.00	0.98	HandFinish5		GP
160	QC	1 pcs	3/29/18	3/29/18	0.00	0.00	QC7-1		GP
165	QC	1 pcs	3/29/18	3/29/18	0.00	0.00	QC5		GP
170	Outsource	1 pcs	3/29/18	3/29/18			SKY002-VC	PO:39556	GP 18/04/10 39556
180	Packaging	1 pcs	3/29/18	3/29/18	0.00	0.00	Packaging2		GP 18/04/10 39556
190	QC	1 pcs	3/29/18	3/29/18	0.00	0.00	QC5		GP 18/04/10 39556
200	SprayPaint	1 pcs	3/29/18	3/29/18	0.00	0.25	Spray Paint		GP 18/04/10 39556
210	QC	1 pcs	3/29/18	3/29/18	0.00	0.00	QC14		GP 18/04/10 39556
220	Crosstubes	1 pcs	3/30/18	3/30/18	0.00	1.69	Crosstubes-1		GP 18/04/10 39556
230	QC	1 pcs	3/30/18	3/30/18	0.00	0.00	QC5		GP 18/04/10 39556
240	Packaging	1 pcs	3/30/18	3/30/18	0.00	0.00	Packaging1-3		GP 18/04/10 39556
250	QC	1 pcs	3/30/18	3/30/18	0.00	0.00	QC4		GP 18/04/10 39556
255	DC	1 pcs	3/30/18	3/30/18	0.00	0.00	DC		GP 18/04/10 39556
260	Packaging	1 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3-1		GP 18/04/10 39556
270	QC21-FG	1 Ea	3/30/18	3/30/18	0.00	0.00	QC21		GP 18/04/10 39556

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101
Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549,using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"
150 - ***IMMEDIATELY AFTER GRINDING***
170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order
180 - Ensure copy of NDT results attached to work order.
190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141
200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 138847 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK

MD 17 Jun 2019

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 174838		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. 1212-604107		Rework Scrap Use-as-is		Cross tube Small Fab Finishing Composite	
NCR No. 19-7145		Suspected Unapproved		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier	
Date: 18-4-7		Step #: 200		QTY Effective: 1	
Description Work Order Deviation		Disposition			
When putting cross tube on rack cross tube fell and hit rack, causing a small dent (.005" deep x .100 long) top of cross tube and middle of bend		- take ultra sonic measurement and record thickness of material. - grind area as per drawing. - take ultra sonic measurement and record thickness			
.003" depth of damage + cleanup. Not region of critical stress, on top of tube which sees compressive stress. Acceptable if NDT is passed. 19/5/10 DAS		DAS MAY 20 2018 41 - got engineering approval 9:00 ** continue on next page **			
Root Cause		FAULT CATEGORY			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter		Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	
No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
MRB (QS1042) Approval PD 18-4-7		Completed By A. Sheldon JUN 07 2018		Lead hand / Supervisor Approval Verification DAS 9 810Z 6 0 NNT 9-89 QC / QA Coordinator Approval DAS 9 JUN 07 2018 9-89	

UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2

clear 138832 Paint 138863

210 - Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 138784 EXP: 9/18

PROSEAL CURE TIME 72 HOURS: Start: 18-6-3 Finish: 18-6-6 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - ***RE-CHECK TORQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY BATCH # TO MATCH W/O

255 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging	
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging	
D3428-1	Placard	1 Ea (1 ea)	240-Packaging	
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging	
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-101TRN	1	8	0
240-Packaging	AN6-35A	4	71	0
	AN6-36A	4	89	0
	D3428-1	1	30	0
	MS21042L6	6	438	0
	NAS1149D0663J	18	1,453	0
	MS21920-25	2		

Part Specifications

33595-063-450 3062603

Specifications could not be found.

Job 173320 Plex 3/22/18 9:41 AM Dart.lajeunesse.marie

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 813 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/02/18

DART
AEROSPACE

Container No: S057211

Part: D212-664-101

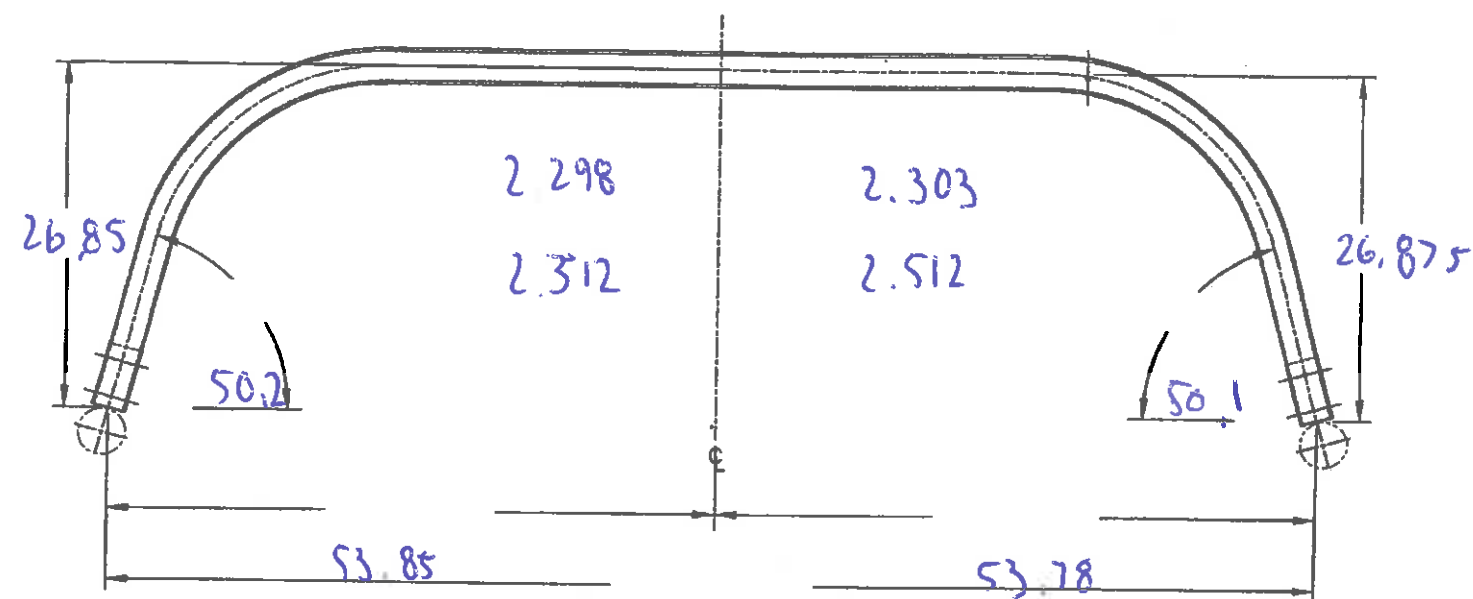
Job No: 174838

Serial No/Batch: S057211

Revision:
Inspector:

DART AEROSPACE LTD		Work Order: 174838
Description: Crosstube High Fwd (205/212/412)		Part Number: D212-664-101
Inspection Dwg: D212-664-141	Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	6	7
Crushing	4.4%	4.3%
Comments		

QC15 Inspection	<i>[Signature]</i>
Date	18-04-02

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (208/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (208/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2	2	2	D2883-1	SUPPORT
6	4	4	4	D8665-083-450	RUBBER CUSHION
7		2		D6017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	AR	AR	AR	PROSEAL 880 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK INSIDE OF CROSSTUBE AS SHOWN (ZN CS-2 / CS-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
f) ANODIZE PER MIL-A-8825, TYPE II, CLASS 1.
g) ALUMINE (DO NOT ETCH) PER QSI 005 4.1.2
h) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
i) MASK INSIDE OF CROSSTUBE AS SHOWN (ZN CS-2 / CS-3, HATCHED AREA)
j) PAINT OUTSIDE PER DART QSI 005 4.2
k) REMOVE MASKING AND APPLY MATTE CLEAR COAT

*NOTE: BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO
CONTAMINATE OR DAMAGE FINISHED SURFACES.

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER 'D212-664-XXX' AND BATCH NUMBER ON INSIDE OF CUFF USING
VIBRATING STYLUS
- 7) WEIGHT: D212-664-141/-141B/-141F = 33.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST
BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.006"
MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- 10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2%
(BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 8% (BASED ON O.D.) ON REMAINING TUBE.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

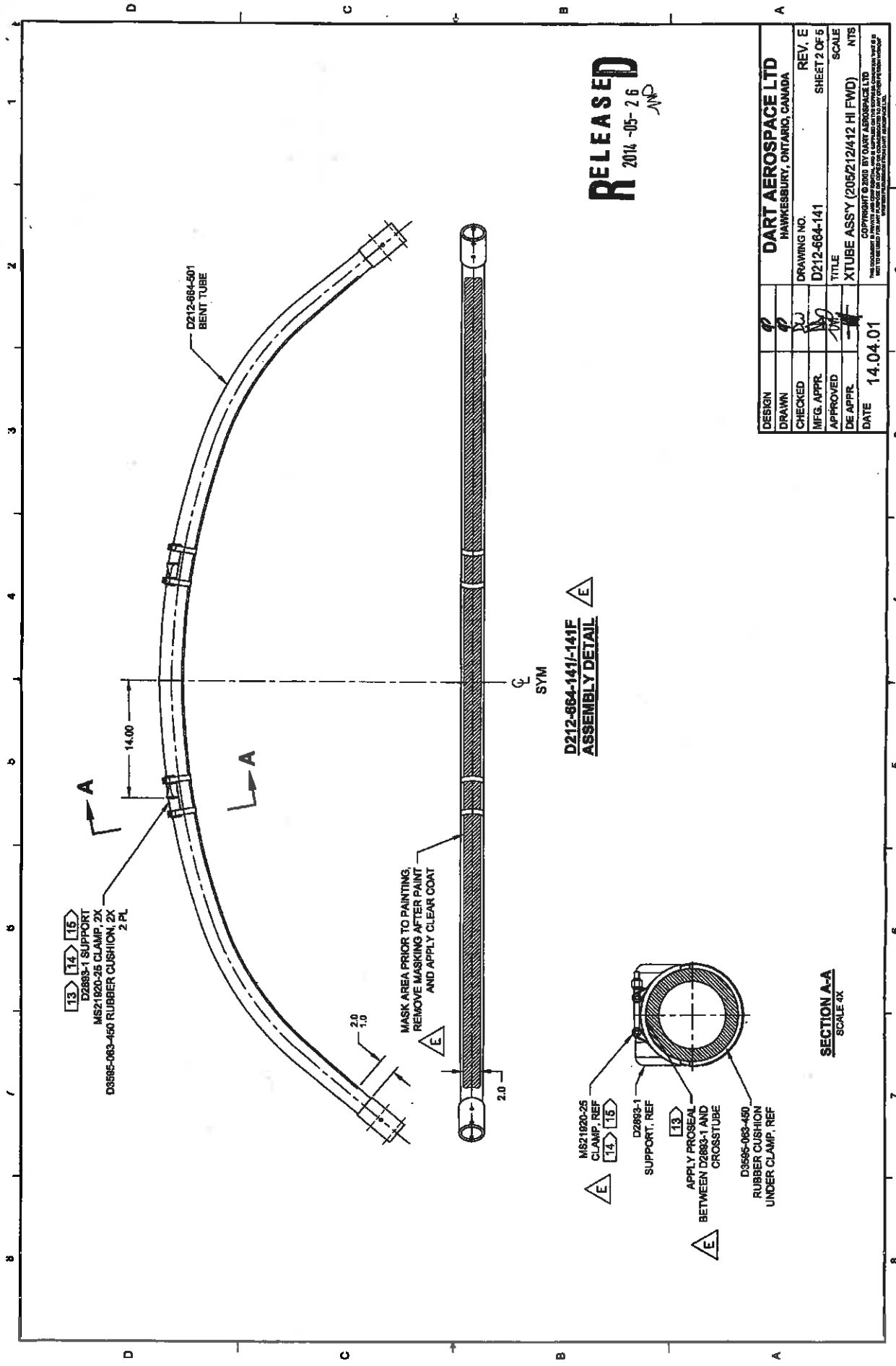
ASSEMBLY

- 13) TO INSTALL D2883-1 / D6017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT
SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL
880 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 14) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3585-083-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP
SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT
BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 880
SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12488 MS
1803-28

RELEASED
2014-05-26
JMD

E	ADD -141F, D6017-1 WAS D2883-1 (-141B), PROSEAL WAS MAGNOBOND. NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL. ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHIPPING (87-2, 87-3), BEND REVERSE TOL. NOW 0.25 WAS 0.19 (C1-3), INCOMP. DEO D-141-3	CP	14.04.01
D	REFORMAT/REUSE GENERAL NOTES/PART LIST REORGANIZED VIEWS AND DIMENSIONS TO CURRENT STANDARDS: ADD -141B (214 HIGH FWD) & B-3; RELOCATED FLAG #8 PER PAR 08-046 (ZN AS-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	06.06.30
C	REMOVE -451 ABRASION STRIP; ADD MAGNOBOND 8888 CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA	PH	06.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR			
APPROVED			
DE APPR			
DATE	14.04.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D212-664-141			
SHEET 1 OF 5			
TITLE XTUBE ASSY (205/212/412 HI FWD)			
SCALE			
NTS			
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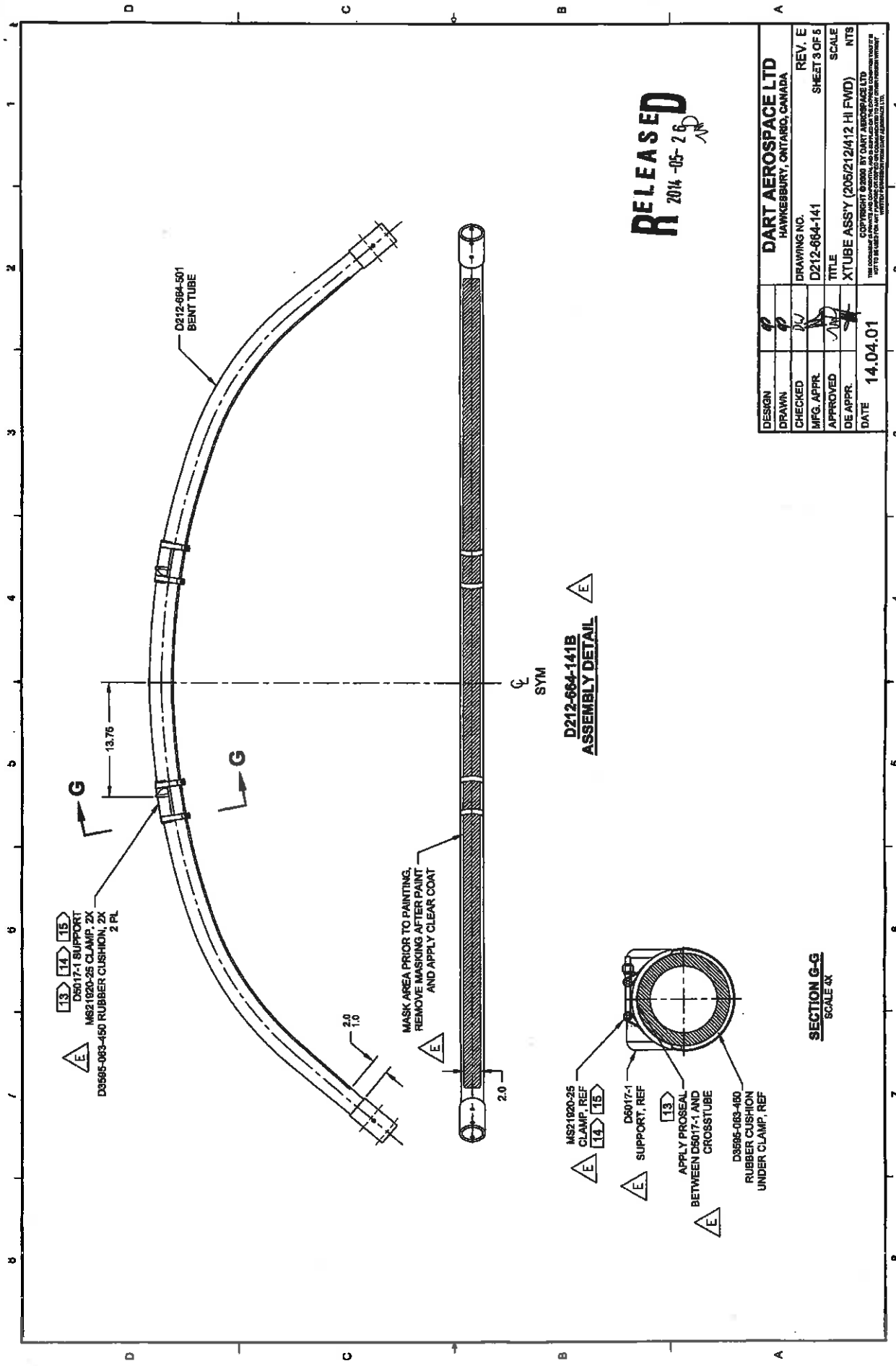


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R 2014-05-26
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D212-864-141F-141F
ASSEMBLY DETAIL

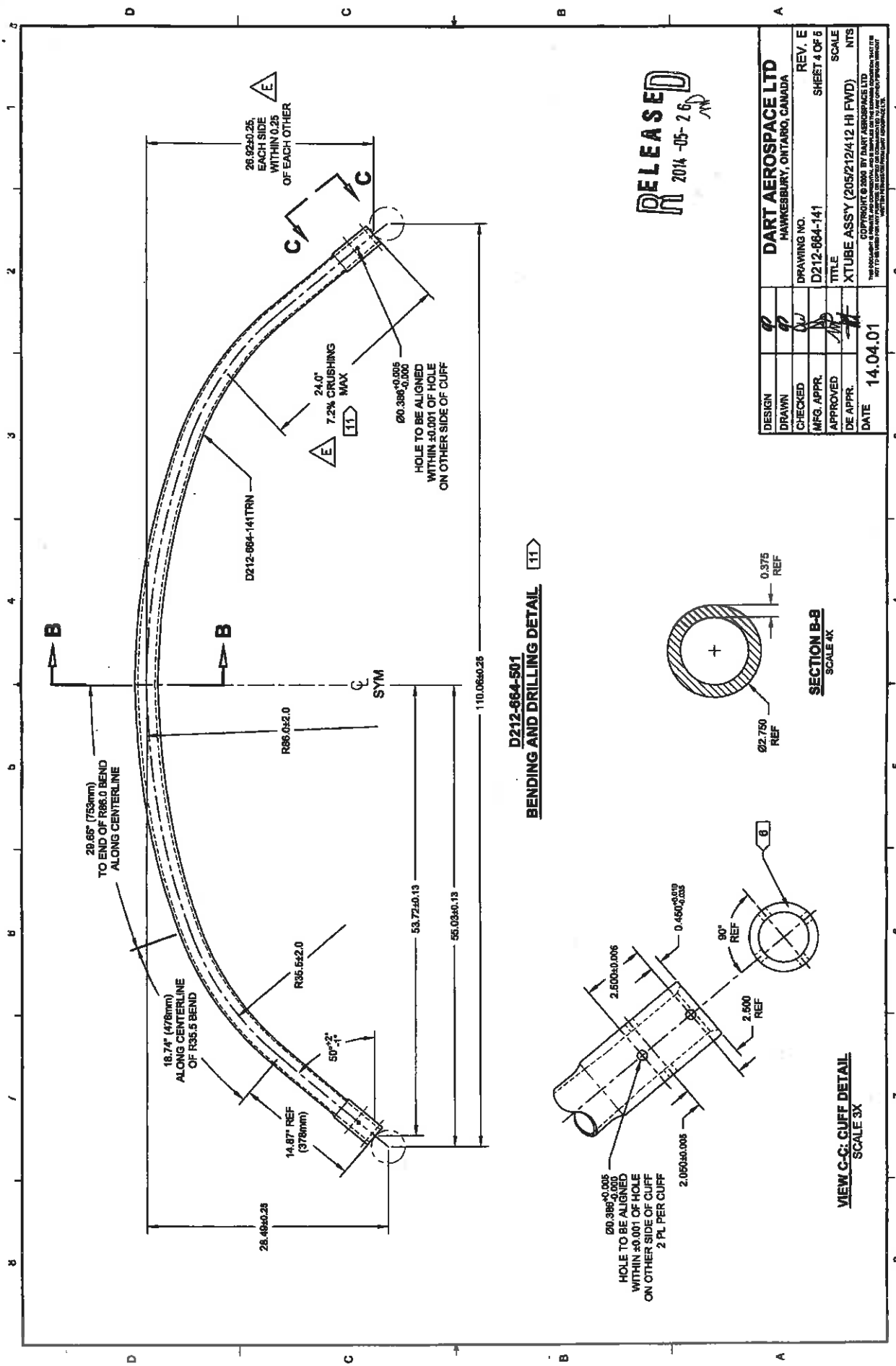
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DRAWN	✓	HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	DRAWING NO.
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APPROVED	✓	TITLE
DE APPR.	✓	XTUBE ASSY (205/212/412 HI FWD)
DATE	14.04.01	SCALE
		NTS

SECTION A-A
SCALE 4X

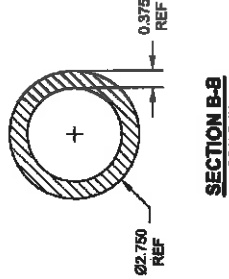
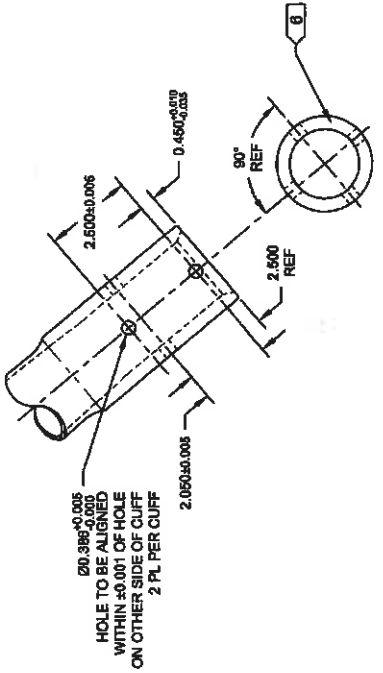


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MFG. APPR.	DART AEROSPACE LTD
APPROVED	DART AEROSPACE LTD
DE APPR.	DART AEROSPACE LTD
DATE	14.04.01
DRAWING NO.	D212-684-141
REV. E	SHEET 3 OF 5
TITLE	XTUBE ASSY (205/212/412 HI FWD)
SCALE	NTS
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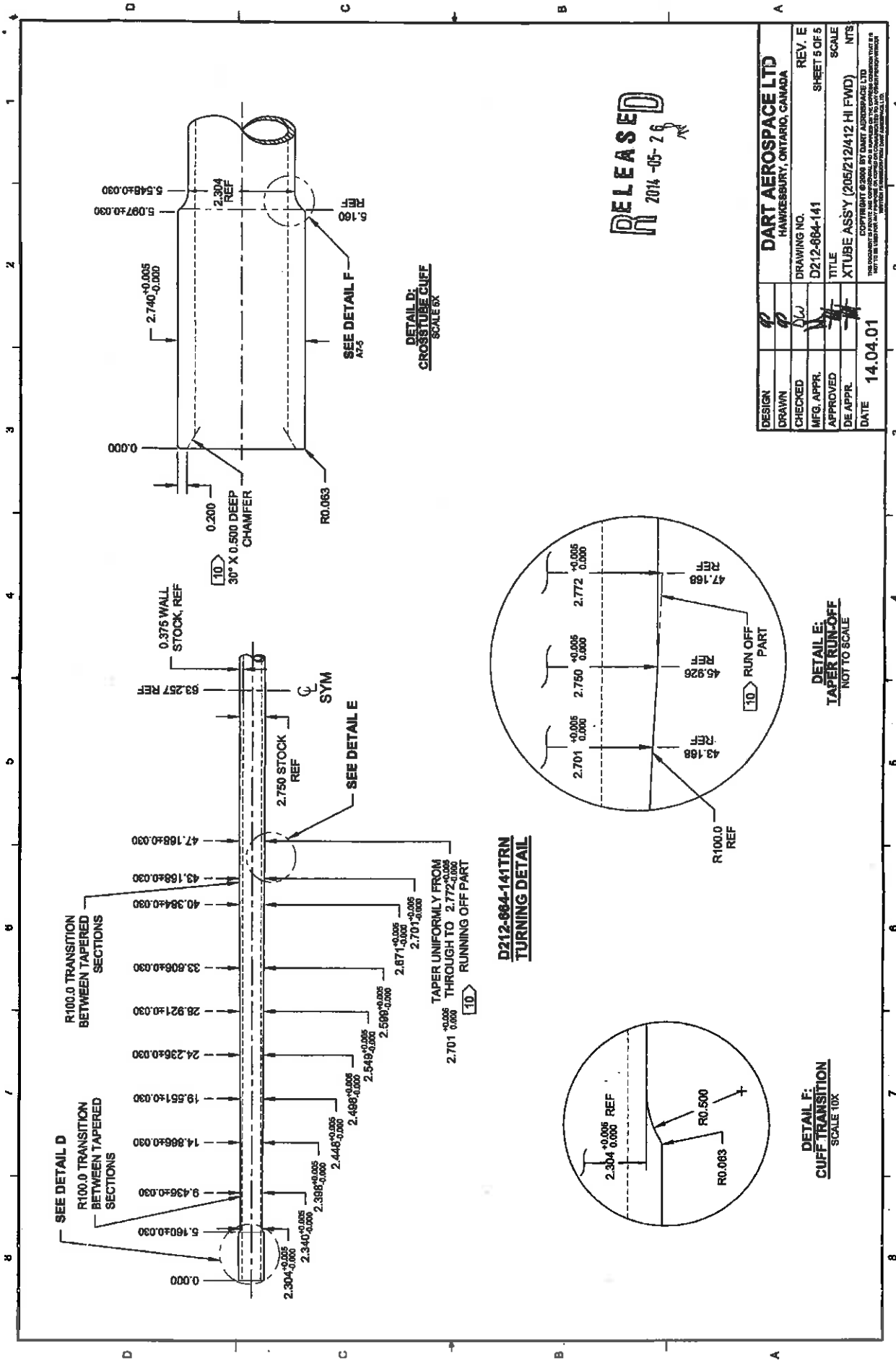
D212-664-501
BENDING AND DRILLING DETAIL 1:1



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2014-05-26

DESIGN	Ø	DART AEROSPACE LTD
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CHECKED	Ø	DRAWING NO.
MFG. APPR.	Ø	D212-664-141
APPROVED	Ø	REV. E
DE APPR.	Ø	SHEET 4 OF 5
DATE	14.04.01	TITLE
		XTUBE ASSY (205/212/412 HI FWD)
		SCALE
		NTS

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DESIGN	0	DART AEROSPACE LTD	REV. E
DRAWN	0	HANWESSBURT, ONTARIO, CANADA	
CHECKED	0	DRAWING NO.	SHEET 5 OF 5
MFG. APPR.	0	D212-884-141	
APPROVED	0	TITLE	SCALE
DE APPR.	0	XTUBE ASSY (205/12/12 HI FWD)	NTS
DATE	14.04.01		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039522

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039522

PO Date: 4/6/18

Due Date: 4/10/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174838	D212-664-101	Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	4/10/18	1 pcs	0 pcs	1 pcs	\$247.75/pcs	\$247.75
	174841			Firmed	4/10/18	1 pcs	1/10 pcs	1 pcs	\$247.75/pcs	\$247.75
Sub Total:						2	0	2		\$495.50

Grand Total: \$495.50

Order Notes

call At 18/4/18

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation..

Plex 4/10/18 12:37 PM dart.lavoie.chantal



skyservice

Work Order Traveler

Sky Service F.B.O. Inc.

105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO35556	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039522
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

2 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 174838 , 174841

1 C-SERIES REMOTE HOOK , P/N# C10-OH , J/S# 173641

1 ELECTRIC SWIVEL , P/N# SWA15A-3-OH , J/S# 175250

Action Taken:						Date:	Initial/Stamp:
LPI AND MPI C/O IAW ASTM E-1417M-13 AND E-1444M-12						APR 06 2018 DAS 38 9-88	[Signature] DOT-APP 20 53-89
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142 MAGBENCH S/N 208123 CAL DUE: 23-JUL-2018 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: [Signature]	ACA/SCA Stamp DOT-APP 20 53-89	Date: APR 06 2018
Name: RAFIK MELIKIAN		

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO039922

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039922
PO Date: 5/16/18
Due Date: 5/24/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

EMAILED
MAY 24 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174840	D212-664-101	Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
	174838			Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
Sub Total:						2	0	2		\$305.00
2	173477	D212-664-201	Aft Crosstube - High ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
	173479			Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
	173480			Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
	177311			Firmed	5/24/18	1 pcs	0 pcs	1 pcs	\$152.50/pcs	\$152.50
Sub Total:						4	0	4		\$610.00

Grand Total: \$915.00

Order Notes

copy 18/05/25



skyservice

Work Order Traveler

Sky Service F.B.O. Inc.

105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #:	MWO36063	Customer:	Dart Aerospace Ltd.	Dept:	NDT YUL	Reference:	PO039922
Descr:		PN:		S/N:		Qty:	1
Make:		Model:		Reg:		A/C S/N:	
TSN:		CSN:		TSO:			

Task:	UNSCHEDULED	Sequence:	1
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Work Required:

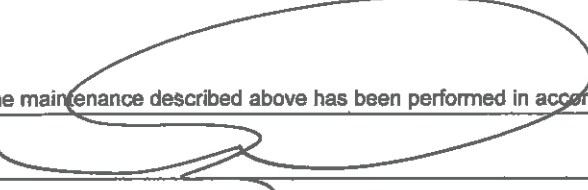
CARRY OUT NDT ON:

2 FWD CROSSTUBES , P/N# D212-664-101 , J/S# 174838 , 174840

4 AFT CROSSTUBES , P/N# D212-664-201 , J/S# 173477 , 173479 , 173480 , 177311

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						MAY 17 2018	 
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp 	Date: MAY 17 2018
Name:	RAFIK MELIKJIAN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master
Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003737	S079084	N6-36A	Bolt	S017086	ST334	4
003737	S079083	N6-36A	Bolt	S056006	ST333	4
003737	S079082	3420-4	Placard	s038568	ST034	1
003737	S079081	S2T042L6	Nut	S041168	ST303	6
003737	S079080	NAS11430060-1J	Washer	S043782	ST263	18

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/7/18 3:22 PM dart.quirion.sonia